

9

Date: Wednesday, 1/30/2008 7:50:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW ASSEMBLY
Job Number : 37050	
Estimate Number : 12128	
P.O. Number :	Part Number : D412729011
This Issue : 1/30/2008 S.O. No. :	Drawing Number : DSK 092 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 36174	Material :
Written By :	Due Date : 2/28/2008 Qty: 1 Um: Each
Checked & Approved By : <u>080130</u>	
Comment : Est Rev: A 05.01.12 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-729-011 CHG003

08/03/07

2.0	37050A	GHW MEDIUM BELL
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Comment: Sub-Component GHW MEDIUM BELL

D412-729-041 B 37050A

5/10

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

08/03/07

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-729-011

Location: PPK 37050A

PPP Rev:

8/3/07 5/10 (x)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/03/07

Job Completion



08/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

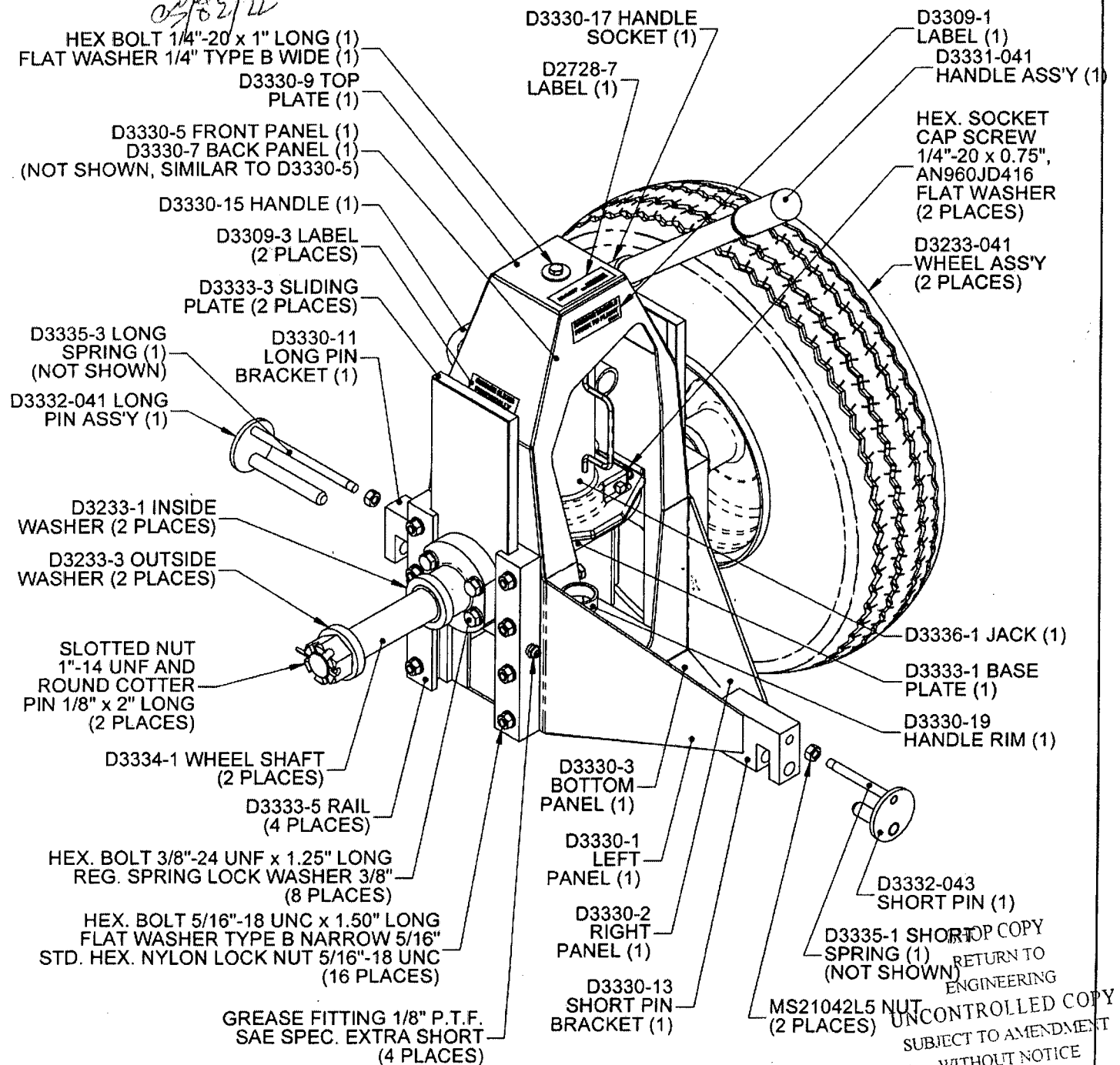
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18	TITLE HYD. GROUND HANDLING	SCALE 1:5	
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

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Date: Wednesday, 1/30/2008 7:50:47 AM
 User: Kim Johnston

Process Sheet

9

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GHW MEDIUM BELL
 Job Number : 37050A
 Estimate Number : 12129
 P.O. Number :
 This Issue : 1/30/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412729041
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : DSK 092 REV B
 Previous Run : 37020 Drawing Revision : B
 Material :
 Due Date : 2/28/2008 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : 08 01 30
 Comment : Est Rev E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-729-041 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-729-041 CHG003

N/A 18

2.0

D27287

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2728-7	Label	<u>22554</u>

SP

3.0

D3233041

Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3233-041	Wheel Assembly	<u>35380</u>

B28609 → 4x

4.0

D32331

Inside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3233-1	Inside Washer	<u>341175</u> (3x)

37073. ✓

8/3/4

SP

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 37050A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32333

Outside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-3 Outside Washer

34176 (2x) 37074 (2x)

SO

6.0

D33091

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3309-1 Label

23767 (1x) 37078 (1x)

SO

7.0

D33093

Label



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3309-3 Label

23767 36197

SO

8.0

D3330041

Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3330-041 Frame Weldment

B37053 -> 2x
B37

9.0

D3331041

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3331-041 Handle Assembly

35440

8/3/4

SO (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 37050A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3332041

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly 36163 ✓

SC

11.0

D3332043

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly 37059 ✓

SC

12.0

D33331

Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate 28618 (2x) ✓

SC

13.0

D33333

Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-3 Sliding Plate 37084 (2x) ✓

8/13/5 SC

14.0

D33335

Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail 36186 (2x) 37085 (2x) ✓

8/13/4 (2x) SC

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 37050A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D33341

Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft

~~B31795~~ → 2x~~B28609~~ → 4x

B 37086 4x

16.0

D33351

Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring

31932 (1x)

259251 ✓

17.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring

34178 → 1x ✓

36702 → 1x

18.0

D33361

Jack



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack

35445

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer

M106271 ✓

20.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

16626

8/3/4

SCD (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 37050A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 CP-21 1/8" Cotter Pin 2" long, Span

21.0

HC12

1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span M16529

50

22.0

HC29

5/16-18 UNC x 1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof M106512

50

23.0

HC153

3/8"-24 UNF x 1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-153 3/8"-24 UNF x 1.25" long Hex Bolt, Span M106162 (10) M107031 (4x)

50

24.0

HN120

HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-120 1" Slotted Nut, Prof M102150 (10) (10)

50

25.0

HN177

5/16-18 UNC Nylon Lock Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-177 5/16"-18 UNC Nylon Lock Nut, Span M106162 (13x) 107631 (3x) 8/3/4

50 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: GHW MEDIUM BELL

Job Number: 37050A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

HX15

1/4-20 UNCx3/4 S.H.C.S.

AM X



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span: 16626

SP

27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M106277

SP

28.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span M102150

SP

29.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB 3/8" Lock Washer, Span M103717

SP

30.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span M106512

8/3/4

SP

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 28/03/07

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 37050A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 5/16"WC Type B Flat Washer (Narrow), Prof

✓ M106737

8/13/4

50

(2X)

32.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

8/8 08/03/07

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/8 08/03/07 (2X)

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: D

8/13/17 50

(2X)

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/8 08/03/07

Job Completion



U 08-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

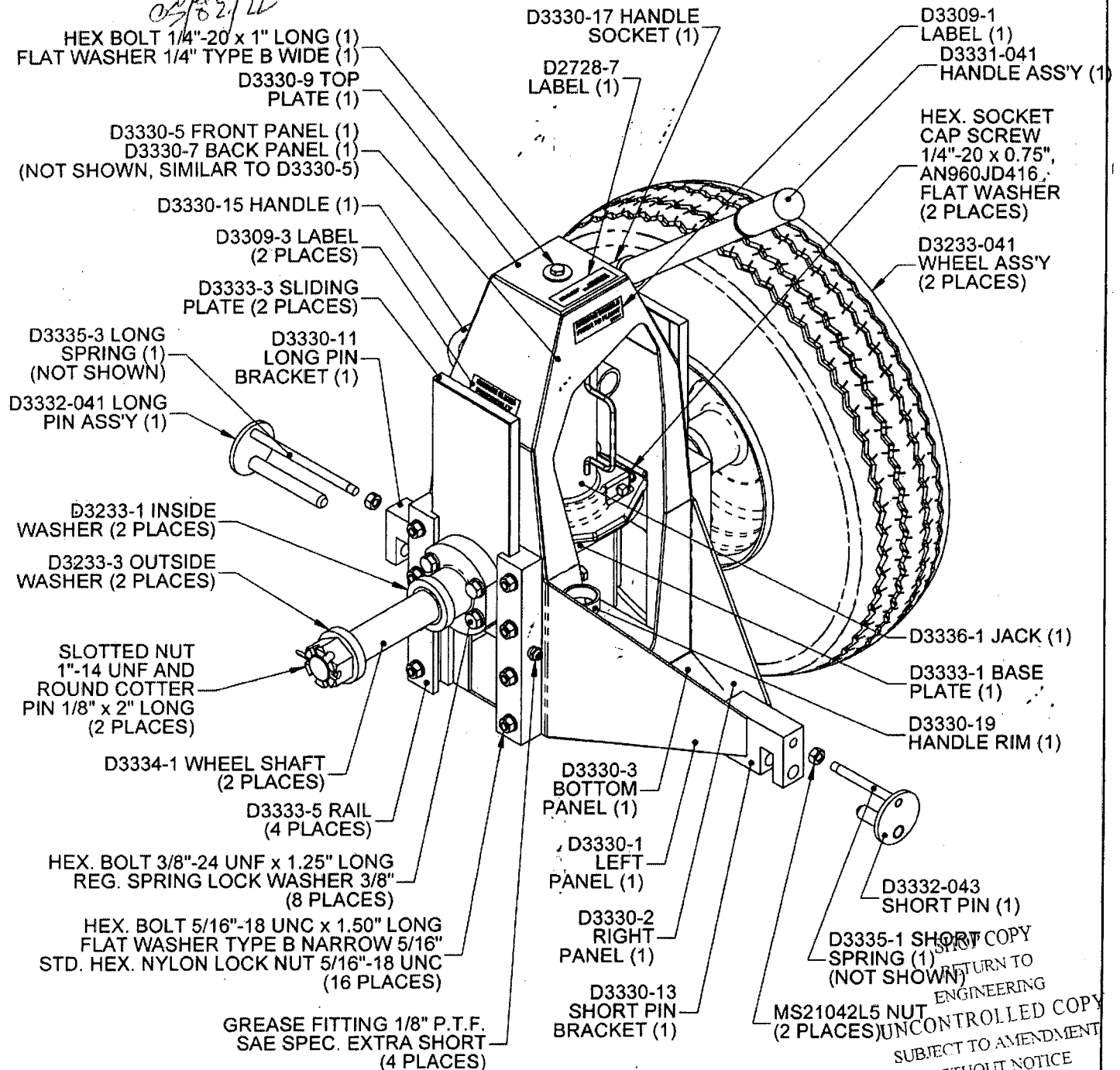
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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RF	APPROVED	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18	TITLE HYD. GROUND HANDLING	SCALE 1:5	
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED
05/02/22**NOTE:**

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

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